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Dart Aerospace Ltd.
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D3407-1
Job Sheet 189156



Part No: D3407-1

Job Qty: 30 pcs

Part Name: Stem



Part Weight: 0 lbs.

Priority: Medium

Job Created: 1/21/19

Status: New

Due Date: 3/15/19

Job Tracking No:

Type: Stock

Created By: Dara Macdonald

Note: IPP Rev:A 05.10.18 New issue KJ/EC IPP Rev:B Now on Doosan 08-05-14 JLM Verified By:DD IPP Rev:C 08-08-12 revE as per dwg (ecn 08-507) DD verified by:EC IPP REV:D 17.11.02 AS PER DWG REV.G DD
VERF.JFS

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Doosan - 1	30 pcs	3/15/19	3/15/19	0.00	12.05	Doosan - 1	[Signature]
110	QC 2	30 pcs	3/15/19	0.00	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	19-02-14
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 38	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 54	
							QC 2 - 56	
							QC 2 - 57	
							QC 2 - 62	



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Container No: S154016



Part: D3407-1

Job No: 189156

Serial No/Batch: S154016

Revision: G

Inspector:

Exp Date:

Date: 02/14/19

Instructions: Various STC's

					QC 2 - 63	
					QC 2 - 8	
120	QC 8	30 pcs	3/15/19	0.00	0.00	QC 8 - 12
						QC 8 - 14
						QC 8 - 17
						QC 8 - 20
						QC 8 - 25
						QC 8 - 3
						QC 8 - 32
						QC 8 - 33
						QC 8 - 35
						QC 8 - 38
						QC 8 - 39
						QC 8 - 4
						QC 8 - 44
						QC 8 - 45
						QC 8 - 49
						QC 8 - 58
						QC 8 - 8
						QC 8 - 9
						QC 8 - 68
						QC 8 - 67
130	Packaging 3-1 - Stock - B4B	30 pcs	3/15/19	0.00	0.00	Packaging 3 - 1 - B4B
						Packaging 3 - 2 - B4B
						Packaging 3 - 3 - B4B
						Packaging 3 - 4 - B4B
						Packaging 3 - 5 - B4B
						Packaging 3 - 6 - B4B
						Packaging 3 - 7 - B4B
						Packaging 3 - 8 - B4B
						Packaging 3 - 9 - B4B
						Packaging 3 - 10 - B4B
						Packaging 3 - 11 - B4B
						Packaging 3 - 12 - B4B
						Packaging 3 - 13 - B4B
						Packaging 3 - 14 - B4B
						Packaging 3 - 15 - B4B
						Packaging 3 - 16 - B4B
						Packaging 3 - 17 - B4B
						Packaging 3 - 18 - B4B
						Packaging 3 - 19 - B4B
						Packaging 3 - 20 - B4B
						Packaging 3 - 21 - B4B
						Packaging 3 - 22 - B4B
						Packaging 3 - 23 - B4B
						Packaging 3 - 24 - B4B
						Packaging 3 - 25 - B4B
						Packaging 3 - 26 - B4B
						Packaging 3 - 27 - B4B
						Packaging 3 - 28 - B4B
						Packaging 3 - 29 - B4B
						Packaging 3 - 30 - B4B
						Packaging 3 - 31 - B4B
						Packaging 3 - 32 - B4B
						Packaging 3 - 33 - B4B
						Packaging 3 - 34 - B4B
						Packaging 3 - 35 - B4B
140	QC 21 - SA	30 pcs	3/15/19	0.00	0.00	QC 21 - SA - 21
						QC 21 - SA - 70

Part Op 100 - 1-Turn as per Folio FA596 Rev: ____ & Dwg D3407 Rev: ____ Mill slot width at max tolerance .260" 2-Debur
 Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)
 120 - (QC8- Inspect parts - second check)
 130 - (Identify as per dwg & Stock Location:_____) LOCATION: WA001
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-R0.750	17-4 Round Bar .750	13.7700 ft (.459 ea) <i>.43</i>	100-Doosan - 1 <i>8.31</i> <i>4.167</i>	<i>S123416</i> <i>S151402</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	M17-4-R0.750	14	10	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Tow Ring	0.063Inches ± 0.010	0.073 0.053	<i>.072</i>	
2	Tow Ring	0.26520Inches + 0.00160 - 0.00170	0.26680 0.26350	<i>2645</i>	1/4-28 UNF
3	Tow Ring	0.24575Inches ± 0.00325	0.24900 0.24250	<i>247</i>	Major ♦
4	Tow Ring	0.625Inches ± 0.010	0.635 0.615	<i>.625</i>	
5	Tow Ring	0.363Inches ± 0.010	0.373 0.353	<i>.363</i>	
6	Tow Ring	0.750Inches ± 0.010	0.760 0.740	<i>.744</i>	
7	Tow Ring	0.100Inches ± 0.010	0.110 0.090	<i>R.1</i>	Radius
8	Tow Ring	0.470Inches ± 0.010	0.480 0.460	<i>.47</i>	
9	Tow Ring	0.500Inches ± 0.010	0.510 0.490	<i>.497</i>	
10	Tow Ring	3.25Inches ± 0.01	3.26 3.24	<i>3.252</i>	
11	Tow Ring	4.250Inches + 0.000 - 0.010	4.250 4.240	<i>4.245</i>	
12	Tow Ring	5.270Inches ± 0.010	5.280 5.260	<i>5.271</i>	
13	Tow Ring	0.150Inches ± 0.010	0.160 0.140	<i>.153</i>	
14	Tow Ring	0.550Inches ± 0.010	0.560 0.540	<i>.553</i>	
15	Tow Ring	0.625Inches ± 0.010	0.635 0.615	<i>.628</i>	
16	Tow Ring	0.250Inches + 0.010 - 0.000	0.260 0.250	<i>.2565</i>	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					